

Date: Wednesday, 01/10/2008 11:21:52 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	350/355 FLOOR WINDOW KIT (INTERIOR)
Job Number :	42371B		
Estimate Number :	13279		
P.O. Number :		Part Number :	D350567031
This Issue :	01/10/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	DSI 9266 REVA
First Issue :	/ /	Project Number :	N/A
Previous Run :	42370B	Drawing Revision :	A
	Type :	Material :	
	SMALL /MED FAB	Due Date :	08/10/2008
Written By :		Qty:	1
Checked & Approved By :	<u>MF 08-10-01</u>	Um:	Each
Comment :	Est Rev:A new issue 08-04-25 DD verified by: LL		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
 Photocopy blue file and create labels per PPP D350-567-031 chg001

NA

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

ENSURE DT 8439 TEMPLATE IS INCLUDED

3.0	DT8439	template
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 template

SP

4.0	D2463	Seal
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Comment: Qty.: 3.7500 f(s)/Unit Total : 3.7500 f(s)
 Neoprene Seal
 batch: 1543841
 1 x 45"

Measured

SP

5.0	D32101	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Doubler
 batch: 1343539

Measured

SP

9/3/10

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 01/10/2008 11:21:52 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 FLOOR WINDOW KIT (INTERIOR)

Job Number: 42371B

Part Number: D350567031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D32111

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

batch: B39743

B39743

SP

7.0

D32121

Floor Window



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Floor Window

batch: B43034

SP

8.0

D3213041

Door Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Door Assembly

batch: B43540

SP

9.0

AN526C632R12

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M110002

SP

10.0

AN960JD6

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M6085

SP

11.0

MS21042L06

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: M116123

SP

12.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)

Rivet, Universal Head

Batch: M169031

9/3/10

(12)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 01/10/2008 11:21:52 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 FLOOR WINDOW KIT (INTERIOR)

Job Number: 42371B

Part Number: D350567031

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	MS20470AD46	Rivet, Universal Head
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Comment: Qty.: 90.0000 Each(s)/Unit Total : 90.0000 Each(s)

Rivet, Universal Head

batch: M109371

50

14.0	MS20470AD47	Rivet, Universal Head
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Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivet, Universal Head

batch: M109631

71

14

50

15.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

9/3/10
090310 ①

16.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-567-031

Location:

PPP Rev:

09/03/10
090310

14

50

17.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/03/10

Job Completion



09.03.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. DSI 9266	REV. A SHEET 1 OF 3
DATE 03.09.11		TITLE ADDITIONAL FLOOR WINDOW KITS SCALE NTS	
A	03.09.11	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION DRAWING D350-567 REV. C

REF. CANADIAN STC: SH92-18

REF. FAA STC: SH989NE / SH990NE

ADD THE FOLLOWING KITS TO INSTALLATION INSTRUCTIONS D350-567 Rev. C

Qty -013	Qty -015	Qty -025	Qty -031	Part Number	Description
X				D350-567-013	REPLACEMENT WINDOW KIT, SMALL
	X			D350-567-015	FLOOR WINDOW INSTALLATION, SMALL, (COMPATIBLE WITH ENERGY ATTENUATING SEATS)
		X		D350-567-025	FLOOR WINDOW INSTALLATION, LARGE (COMPATIBLE WITH ENERGY ATTENUATING SEATS)
			X	D350-567-031	INTERIOR FLOOR WINDOW KIT (COMPATIBLE WITH ENERGY ATTENUATING SEATS)
1	1			D2126-0600	SEAL
	1	1	1	D2463-0450	NEOPRENE SEAL
		1		D2463-0750	NEOPRENE SEAL
	1	1	1	D3210-1	DOUBLER
	1	1	1	D3211-1	BRACKET
	1	1	1	D3212-1	FLOOR WINDOW
	1	1	1	D3213-041	DOOR ASSEMBLY
1	1			D2125	REPLACEMENT WINDOW, SMALL
		1		D2942	REPLACEMENT WINDOW, LARGE
2 SQ. YD	2 SQ. YD	2 SQ. YD		N/A	7.5 OZ VOLAN GLASS CLOTH
	8		8	AN526C632R12	SCREW (OR AN526C632-12)
	8		8	AN960JD6	WASHER
	8		8	MS21042L06	NUT (OR MS21042-06)
		9		2600-6	1/4 TURN FASTENER
		9		2600-LW	WASHER
		9		212-12	RECEPTACLE
		22		AN526C832R9	SCREW (OR AN526C832-9)
		44		AN960JD8	WASHER
		22		MS21042L08	NUT (OR MS21042-08)
	40	40	40	MS20470AD4-5	RIVET
	90	90	90	MS20470AD4-6	RIVET
	20	20	20	MS20470AD4-7	RIVET
		20		MS20470AD3-5	RIVET

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 03.09.11
CERT. NO.: SH92-18
ISSUE NO.: 5

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DESIGN <i>IP</i>	DRAWN BY <i>IP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9266	REV. A SHEET 2 OF 3
DATE 03.09.11		TITLE ADDITIONAL FLOOR WINDOW KITS SCALE NTS	

INSTALLATION OF D350-567-013 REPLACEMENT WINDOW KIT, SMALL

The D350-567-013 kit is composed of an exterior window that installs in the 350A21-0024-00A1 fairing (or equivalent), and is intended to be used as a replacement window for Dart kits that use the smaller exterior window (D350-567-011/-015). Install the window per Section 3.4 (page 6) of Installation Instructions D350-567 Rev. C.

INSTALLATION OF D350-567-015 FLOOR WINDOW INSTALLATION, SMALL, (COMPATIBLE WITH ENERGY ATTENUATING SEATS)

The D350-567-015 installation is composed of a small exterior window that installs in the 350A21-0024-00A1 fairing (or equivalent) and an interior window that installs in the aircraft cockpit floor. This kit is compatible with Eurocopter's Energy Attenuating Seats and provides all the hardware necessary for vertical reference viewing as described in the Installation Instructions.

Install the D2125 Window per Section 3.4 (page 6) of Installation Instructions D350-567 Rev. C. Install the D3212-1 Floor Window per Section 3.5 (page 9) of Installation Instructions D350-567 Rev. C using the hardware shown in Figures 1 and 2 of these instructions (DSI9266 Rev.A).

INSTALLATION OF D350-567-025 FLOOR WINDOW INSTALLATION, LARGE (COMPATIBLE WITH ENERGY ATTENUATING SEATS)

The D350-567-025 installation is composed of a large exterior window that installs in the 350A21-0024-00A1 and 350A21-0025-02 fairings (or equivalents) and an interior window that installs in the aircraft cockpit floor. This kit is compatible with Eurocopter's Energy Attenuating Seats and provides all the hardware necessary for vertical reference viewing as described in the Installation Instructions.

Install the D2942 Window per Section 3.5 (page 9) of Installation Instructions D350-567 Rev. C. Install the D3212-1 Floor Window per Section 3.5 (page 9) of Installation Instructions D350-567 Rev. C using the hardware shown in Figures 1 and 2 of these instructions (DSI9266 Rev.A).

INSTALLATION OF D350-567-031 INTERIOR FLOOR WINDOW KIT (COMPATIBLE WITH ENERGY ATTENUATING SEATS)

The D350-567-031 kit is composed of an interior window that installs in aircraft cockpit floor and is compatible with Eurocopter's Energy Attenuating Seats. This kit is intended as a conversion kit to make existing Dart kits compatible with Energy Attenuating Seats.

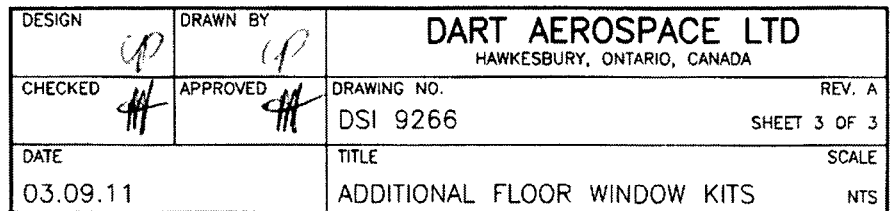
Install the D3212-1 Floor Window per Section 3.5 (page 9) of Installation Instructions D350-567 Rev. C using the hardware shown in Figures 1 and 2 of these instructions (DSI9266 Rev.A).

42371B

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	03.09.11
CERT. NO.:	SH92-18
ISSUE NO.:	5

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STA 50.95

STA 70.47

FWD

INBOARD

OUTBOARD EDGE OF FLOOR

EXISTING RIVNUTS (3 PLACES)

D3210-1 DOUBLER

AN526C632R12 SCREW

AN960JD6 WASHER

MS21042L06 NUT

TRANSFER DRILL HOLES TO AIRCRAFT FLOOR (8 PLACES, #0.141 HOLES REF)

MS20470AD4-6 RIVET, TRANSFER DRILL TO DOUBLER FROM AIRCRAFT FLOOR (38 PLACES)

MS20470AD4-5 RIVET, TRANSFER DRILL FROM DOUBLER TO AIRCRAFT FLOOR (34 PLACES)

D3211-1 BRACKET

MS20470AD4-6 RIVET (46)

D3212-1 FLOOR WINDOW

D2463-0450 SEAL

TRIM SEAL TO FIT AROUND EDGE OF WINDOW

OUTBOARD EDGE OF PILOT'S SEAT ATTACHMENT STRIP

MS20470AD4-7 RIVET, TRANSFER DRILL FROM DOUBLER TO AIRCRAFT FLOOR (12 PLACES)

D3213-041 DOOR ASSEMBLY

AN526C632R12 SCREW (REF)

MS20470AD4-6 RIVET (REF)

MS20470AD4-5 RIVET (REF)

D3210-1 DOUBLER (REF)

FLOOR SKIN (REF)

D3212-1 FLOOR WINDOW (REF)

AN960JD6 WASHER (REF)

MS21042L06 NUT (REF)

D3211-1 BRACKET (REF)

D2463-0450 SEAL (REF)

MS20470AD4-6 RIVET (REF)

SECTION C-C
(TYPICAL FLOOR SECTION)

FIGURE 2 - REPLACEMENT PARTS
(PARTS SHOWN FOR REFERENCE ONLY)

STA 50.95

STA 70.47

D2728-1 DECAL

D2137 DECAL

D2419 HANDLE

MS20470AD4-4 RIVET

AN960JD6 WASHER

D2728-1 DECAL

NO STEP

D3213-3 DOOR PANEL

D2462-0210 SEAL

D3161-3 HINGE

MS20470AD4-4 RIVET (16)

D3213-1 DOOR PANEL

D2462-0034 SEAL (2)

D3161-3 HINGE

MS20470AD4-4 RIVET (8)

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